

304 1.50

## Work Order ID 73619

Wednesday, September 07, 2011 2:36:21 PM



Page 1

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 9/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

0.00

100



Doosan

Memo

0.00

Doosan Lathe

I-TURN AS PER FOLIO FA588 & DWG D3443  
FOLIO REV: A  
DWG REV: e  
2-DEBURR AS REQUIRED

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

160

QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

B.A 11/10/05

10 ✓

11/10/04

10 ✓

11/10/04

10 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 73619

Wednesday, September 07, 2011 2:36:21 PM



Page 2

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 9/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

170



Packaging

Packaging

Operation  
Description

Identify as per dwg & Stock Location: WA

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

(OK) SP 11-10-6

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/11 JF  
JMF 11-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, September 07, 2011 2:36:18 PM

Page 1

Work Order ID: 73619



Parent Item: D3443-3



Parent Item Name: Clevis

Start Date: 9/7/2011

Required Date: 9/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A 05.11.14 New issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.500 		Purchased	No			100	f	9.3520	303 0.25	2.5 		11/01/04 	

304 round bar 1.500

Location	Loc Qty	Loc Code
MAT029	9.352	
106260	0.272	
10676	9.08	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	73619
Description: Clevis	Part Number:	D3443-3
Inspection Dwg: D3443	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.206	/		SA-9	
0.95	+/-0.030	.952	/			
Ø0.500	+0.000/-0.005	Ø.498	/			
20°	+/-0.5°	20°	/			
R0.450	+/-0.010	R.450	/			
Ø0.375	+0.006/-0.001	Ø.377	/			
0.451	+/-0.010		/			
0.625	+/-0.010	.625	/			
1.43	+/-0.030	1.435	/			
0.720	+/-0.010					
0.05 x 45°	+/-0.5°	-0.05 x 45°	/			
45°	+/-0.5°	45°	/			
1.00	+/-0.030	1.00	/			
1.125	+/-0.010	1.125	/			
0.438	+0.005/-0.000	0.439	/			
R0.219	+/-0.010	R.219	/			
.551	± .010	.550	/			Rev. C
.820	± .010	.820	/			Rev. C

Measured by:	
Date:	11/10/04

Audited by:	G.A.
Date:	11/10/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev C	KJ	M

8      7      6      5      4      3      2      1

1

1

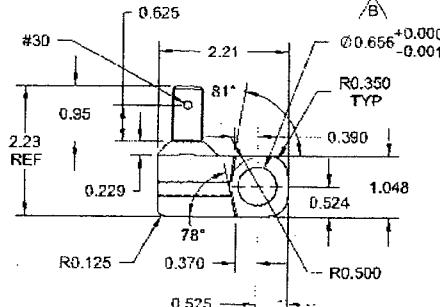
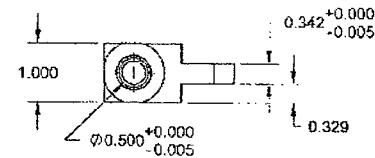
8

1

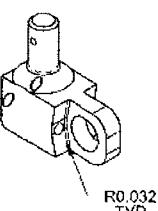
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B

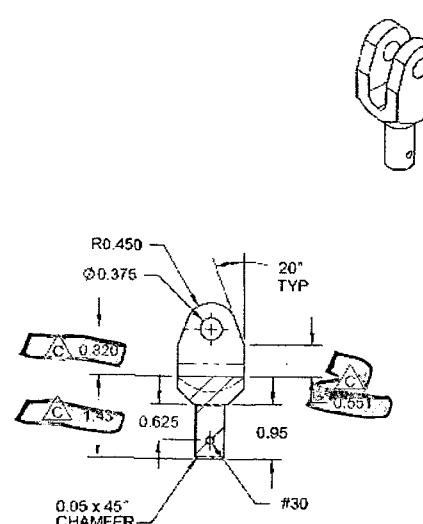
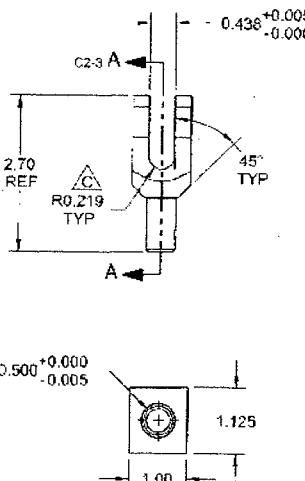
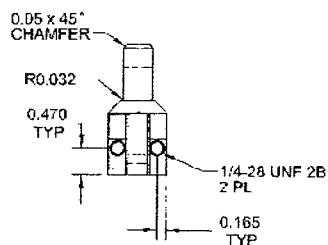
A



D3443-1 LUG



R0.032  
TYP



**SECTION A-A** C4-

D3443-31CLEVIS

RELEASED  
01/28/2014

**NOTES:**

**NOTES:**

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)  
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs  
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY LNTS	
DATE	09.06.25	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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